

**Work Order ID 111268****\*111268\***

Page 1

Thursday, January 09, 2014 2:40:49 PM

Item ID: D350-636-018

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 1/9/2014 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/13/2014 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan:  Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4168-044	B

100

0.00

**\*100\***

DOCUMENT CONTROL



DC

Memo 

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-018 CHG 005

89.3°    
14-2-20

# Work Order ID 111268

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Item ID: D350-636-018

Accept

**\*N9000040100\***

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Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 1/9/2014 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/13/2014 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

**\*110\***

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

✓ 1- Pick D2600-3 Bent

✓ 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

✓ 5- Drill fwd step holes using DT9616 detail AA. Ensure proper positioning.

6- Drill pilot holes using drill Jig DT8150 & DT8864A for first side only DT8864B for second side section BE-BE and BC-BC

7- Clecko DT8864B on second side of tube and drill pilot holes for section BE-BE and BC-BC \*\*\*SECOND SIDE\*\*\*


8-Drill pilot holes for wearplates as per Dwg D4168 using DT9678. Locating from 66.54" holes.

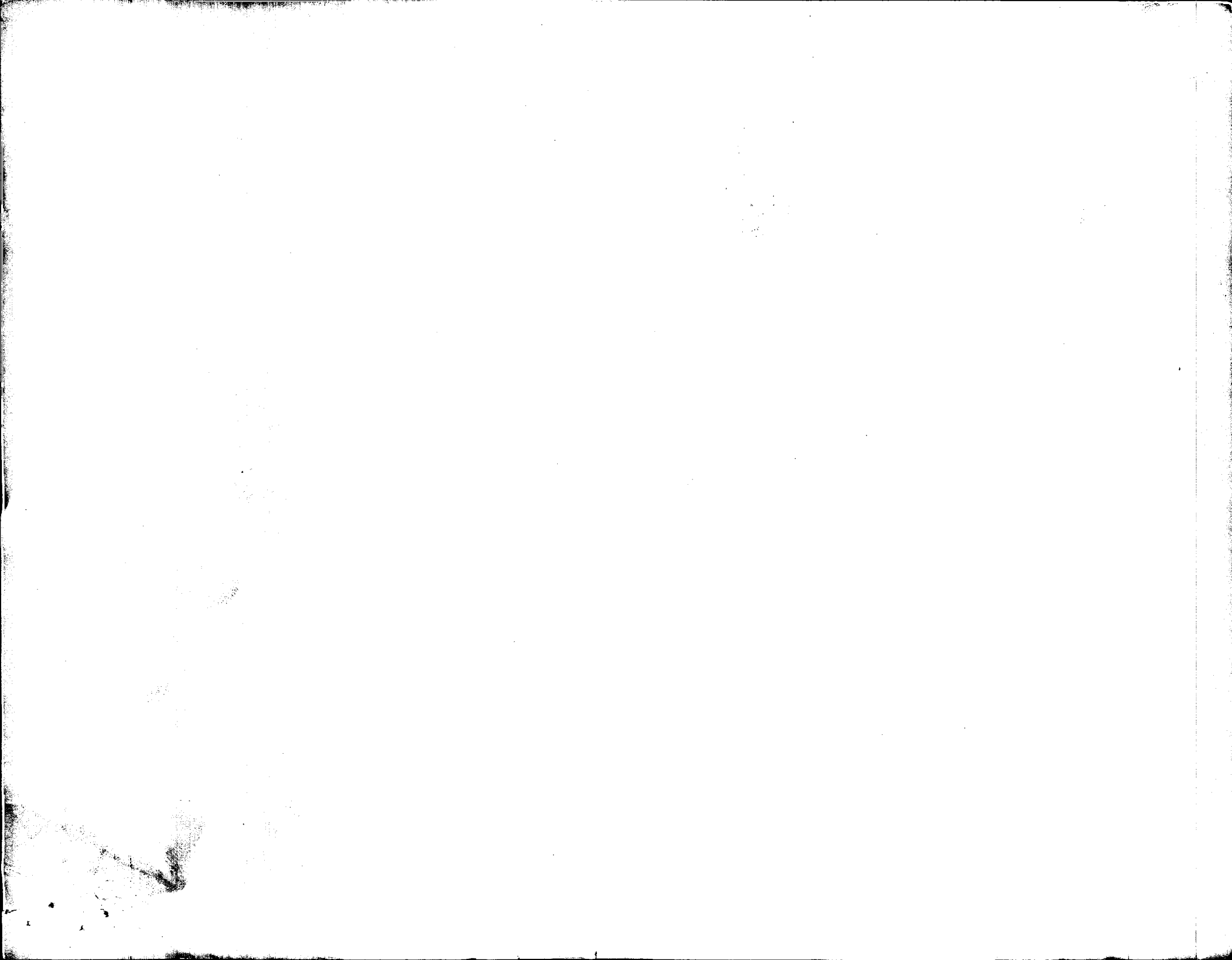
9-Open up holes of Detail A to 0.297" (total of 2 holes per side) +.201" holes Detail AA.

10-Weld D2744 Cap as per Dwg D4168 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: M126325 SE140201

DGL 14-1-31

 14-2-20



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**\*1 1 1 268\***

**Item ID:** D350-636-018

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

**Item Name:** Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Stop \*NS2\*

**Start Date:** 1/9/2014      **Start Qty:** 1.00      **\* 1 \***

**Cust Item ID:**

**Required Date:** 1/13/2014      **Req'd Qty:** 1.00      **\*1\***

**Customer:**

**Reference:**

<b>Approvals:</b>	<b>Process Plan:</b> _____	<b>Date:</b> _____	<b>Tooling:</b> _____	<b>Date:</b> _____
	<b>QC:</b> _____	<b>Date:</b> _____	<b>SPC (Y/N):</b> _____	<b>Date:</b> _____

Run	Start	*NR1*
	Stop	*NR2*

[illegible]



**Work Order ID 111268**

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**Item ID:** D350-636-018**Accept****\*N900040100\*****Setup Start \*NS1\*****Revision ID:****Stop \*NS2\*****Item Name:** Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible**Start Date:** 1/9/2014 **Start Qty:** 1.00 **\*1\*****Cust Item ID:****Required Date:** 1/13/2014 **Req'd Qty:** 1.00 **\*1\*****Customer:****Reference:**

**Approvals:** **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Run Start \*NR1\*****Stop \*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

**Memo**

0.00

Hand Finishing

14-2-27 JGL

150

QC7-Inspect Chemical Conversion Coat

0.00

**\*150\***

QC

**Memo**

0.00

Quality Control

DP 14-2-28



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Item ID: D350-636-018

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 1/9/2014 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/13/2014 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00

**\*160\***

Skidtubes

Skidtubes

**Memo**

0.00

1-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168.

2-Open up holes of wearplate holes to 0.375" section CK-CK (total of 4 holes per side) 0.3125" holes section BC-BC (4 per side) as per dwg D4168.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes dwg D4168 (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required

7-Bond web D2739 in place as per QSI015

A/R Sikaflex-291

batch: 127918exp. date: 14-8-168- Weld spacers as per dwg D4168 & QSI004  
(welding instructions on sheet 11)A/R Aluminum Rod batch: M127763

9- Grind welds flush as per Dwg D4168

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168

14-2-28

BR 14-03-04

DGL 14-3-5



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Item ID: D350-636-018 Accept **\*N9000040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible  
 Start Date: 1/9/2014 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 1/13/2014 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11- C'bore section CK-CK. ADJUST TOOLING AS REQUIRED. VERF BY: <u>DL</u>								
	✓ 12- Deburr holes								
	***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN TUBE ***** <u>Ref to B106907</u>								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
									08-6 6 SVQ
180	QC5- Inspect part completeness to step on W/O	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									
									08-6 6 SVQ

14-3-10  
 ① 14-03-11  
 ① 14-03-11



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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

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Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

Pressure Wash per QSI005 4.3

0.00

**\*100\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 7614-313

200

0.00

**\*200\***

SprayPaint

Memo

0.00

Spray Painting

1- PRIME AS PER DWG AND QSI 005 4.2

PRIMER PRC DESOTO 515X349 BATCH: 126573

2- PAINT WHITE AS PER DWG AND QSI 005 4.2

PAINT BATCH: 128574

1 0 0 AB  
14-3-23

210

QC14- Inspect Spray Paint

0.00

**\*210\***

QC

Quality Control

Memo

Inspect for foreign object per QSI 024

DAS  
27  
10-59  
14/3/24

1311 0 0 11/03/21

**\*1 1 1 268\***

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**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Item Name:** Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

**Start Date:** 1/9/2014      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 1/13/2014      **Req'd Qty:** 1.00      **\*1\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Stop** **\*NR2\***

### Operation Description

### Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

0.00

**\*230\***

## HandFinishing

HandFinish

## Memo

0.00

## Hand Finishing

1- Install inserts as per Dwg D4168

## 2-Inspect for Foreign Objects

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M 128026

EXP DATE: 14/10

4-assemble o'ring to plug as per dwg D3492, and apply o'ring lube

A/R 55-o'ring lube batch: *111(21631*

5-Coat all exposed fasteners with "LPS Procyon" batch: M 12290c

240

QC5- Inspect part completeness to step on W/O	0.00
---	------

**\*240\***

QC

## Memo

0.00

## Quality Control



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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
<b>*250*</b>									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
<b>*260*</b>									
QC	Memo	0.00							
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								
270	Packaging	0.00							
<b>*270*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-636-018								
	Location: _____								
	PPP rev: _____								

DAS  
28  
9-89

DAS  
31  
9-89

106907  
218 (5)

DAS  
06  
9-89

MAR 27 2014

DAS  
06  
9-89

MAR 27 2014

106907

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**Item ID:** D350-636-018**Accept****\*N900040100\*****Setup Start \*NS1\*****Revision ID:****Stop \*NS2\*****Item Name:** Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible**Start Date:** 1/9/2014 **Start Qty:** 1.00 **\*1\*****Cust Item ID:****Required Date:** 1/13/2014 **Req'd Qty:** 1.00 **\*1\*****Customer:****Reference:**

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**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Run Start \*NR1\***  
**Stop \*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

*pl 14-03-31*  
*MC 1403-2A*





# Picklist Print

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Work Order ID: 111268

**\*111268\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B  
11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as per  
NCR 11-906 DD verf:EC IPP Rev:D 112.04.16 AS PER ECN 12-  
542 DD verf:EC IPP REV:E 13.08.28 PER ECN13-594 DD  
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3490-1		Manufactured	No			160	Each	209.0000	4	4			
<b>*D3490-1*</b>									<b>**</b>				
Cross Bolt Spacer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG001		209							
				107419		41							
				109932		168							
AN3C34A		Purchased	No			230	Each	50.0000	1	1			
<b>*AN3C34A*</b>									<b>**</b>				
BOLT													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST352		50							
				m127044		50							

BE14-03-04

B 112737 x 4

DAS 14-03-27

28  
9-89

DAS  
06  
9-89

DAS  
31  
9-89

1x

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**\*111268\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

AN3C36A Purchased No 230 Each

Start Qty: 1.00  
213.0000 4 4

Required Qty: 1.00

**\*AN3C36A\***

Bolt

\*\*

*lll 11031201*

Location

Loc Qty

Loc Code

FG	25
101261	4
122204	11
124827	10
ST354	38
m127578	38
ST514	150
m127769	100
m127770	50

*x 4*

AN3C37A Purchased No 230 Each

127.0000 1 1

**\*AN3C37A\***

BOLT

\*\*

DAS  
28  
9-89

*14-03-27*

Location

Loc Qty

Loc Code

ST324	4
M121068	4
ST353	123
M126345	48
M127823	75

*IX*

DAS  
06  
9-89

DAS  
31  
9-89

AN3C42A Purchased No 230 Each

32.0000 1 1

**\*AN3C42A\***

Bolt

\*\*

DAS  
28  
9-89

Location

Loc Qty

Loc Code

FG	5
121103	5
ST353	27
m126293	2
m127300	25

*128491*

DAS  
06  
9-89

DAS  
31  
9-89

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Work Order ID: 111268

**\*111268\***

Parent Item: D350-636-018

**\*D350-636-018\***Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float  
Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

D3488-042

Manufactured No

230 Each

Start Qty: 1.00  
19.0000 1 1

Required Qty: 1.00

**\*D3488-042\***

Blade Fitting RH

\*\*

11/03/2014

LocationLoc QtyLoc Code

FP001

19

106658

6

109134

10

98887

3

Y1

D3490-5

Manufactured No

230 Each

96.0000 4 4

**\*D3490-5\***

Cross Bolt Spacer

\*\*

BB 11-03-04

LocationLoc QtyLoc Code

LG001

96

101067

6

104851

49

109104

41

4

D3492-1

Manufactured No

230 Each

195.0000 8 8

**\*D3492-1\***

Plug

\*\*

11/03/2014

LocationLoc QtyLoc Code

FP001

195

104844

195

B112738

Y8

D3492-5

Manufactured No

230 Each

144.0000 8 8

**\*D3492-5\***

Plug

\*\*

11/03/2014

LocationLoc QtyLoc Code

FP001

144

104854

65

105612

79

X8

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Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

D3873-1

Manufactured No

230 Each

Start Qty: 1.00  
406.0000 7 7

Required Qty: 1.00

**\*D3873-1\***

Bushing

\*\*

*ll 1/10/3/21*

Location

Loc Qty

Loc Code

ST067

406

104858

84

105611

301

109110

21

*x 7*

D4154-041

Manufactured No

230 Each

4.0000 1 1

**\*D4154-041\***

Wearplate Assembly

\*\*

*ll 1/10/3/21*

Location

Loc Qty

Loc Code

FP002

4

106716

4

*13111473*

*x 1*

D4170-1

Manufactured No

230 Each

159.0000 4 4

**\*D4170-1\***

Bushing

\*\*

*BE 1/10-03-04*

Location

Loc Qty

Loc Code

LG001

159

107681

34

107896

125

*4*

D4171-1

Manufactured No

230 Each

33.0000 1 1

**\*D4171-1\***

Bushing

\*\*

*ll 1/10/3/21*

Location

Loc Qty

Loc Code

ST098

33

109144

22

99276

11

*x 1*

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**\*111268\***

Parent Item: D350-636-018

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Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

MS21043-3 Purchased No 230 Each 899.0000 5

Start Qty: 1.00

Required Qty: 1.00

**\*MS21043-3\***

Nut

\*\*

Location

Loc Qty

Loc Code

FG	80
103691	80
GA	4
m126741	4
ST315	815
124555	92
m126741	723

11128398

x4

NAS1149C0363R

Purchased No

230 Each

1,043.000 9

**\*NAS1149C0363R\***

Washer

\*\*

Location

Loc Qty

Loc Code

FP001	704
114742	704
ST292	339
122441	339

x7

NAS1515H3L

Purchased No

230 Each

454.0000 4

**\*NAS1515H3L \***

Washer

\*\*

Location

Loc Qty

Loc Code

FG	40
102472	40
ST297	414
124542	14
m127831	400

v4

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**\*111268\***

Parent Item: D350-636-018

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Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float  
Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

NAS1611-005

Purchased

No

230

Each

Start Qty: 1.00  
192.0000 8 8

Required Qty: 1.00

**\*NAS1611-005\***

O-RING

\*\*

11/03/24

Location

Loc Qty

Loc Code

FP001

192

m125807

4

m126974

188

VB

NAS1611-010

Purchased

No

230

Each

195.0000 8 8

**\*NAS1611-010\***

O-RING

\*\*

11/03/24

Location

Loc Qty

Loc Code

FP001

195

m126988

45

m127813

150

11/28/375

X2

NAS1149D0863J

Purchased

No

250

Each

991.0000 2 2

**\*NAS1149D0863.J\***

Washer

\*\*

11/03/24

Location

Loc Qty

Loc Code

FP001

6

118078

6

ST293

185

125484

185

ST510a

800

125268

600

125635

200

X2

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Page 6



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Page 7

Work Order ID: 111268

**\*111268\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

D2744

Manufactured No

110

Each

Start Qty: 1.00  
49.0000 1 1

Required Qty: 1.00

**\*D2744\***

Cap

\*\*

*BE 1402-21*

Location

Loc Qty

Loc Code

LG001

49

*100398*

28

97543

21

D2600-3-BENT

Manufactured No

110

Each

3.0000 1 1

**\*D2600-3-BENT\***

Extrusion Bent

\*\*

Location

Loc Qty

Loc Code

LG002

3

*111606*

3

109789

D2743

Manufactured No

160

Each

299.0000 8 8

**\*D2743\***

Crossbolt Spacer

\*\*

*BE 1403-04*  
*B 111570 x8*

Location

Loc Qty

Loc Code

LG001

299

106245

9

107359

36

107907

122

109799

132

D2739

Manufactured No

160

Each

5.0000 1 1

**\*D2739\***

350 I Beam

\*\*

*14-3-5*

Location

Loc Qty

Loc Code

LG002

5

*111094*

5

109973

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Page 8

Work Order ID: 111268

**\*111268\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

ALS4-1032-225

Purchased

No

230

Each

Start Qty: 1.00  
380.0000 4 4

Required Qty: 1.00

**\*AI S4-1032-225\***

Rivnut

\*\*

*ll 11/03/24*

Location

Loc Qty

Loc Code

FG	30
M127028	30
ST280	10
M127028	10
st555	340
M127092	340

*M128179*

*✓*

AN8C35A

Purchased

No

230

Each

125.0000 1 1

**\*AN8C35A\***

Bolt

\*\*

*ll 11/03/24*

Location

Loc Qty

Loc Code

FG	4
121275	4
FP001	121
m126293	47
m127061	24
m127823	50

*✓*

AN6C44A

Purchased

No

230

Each

56.0000 4 4

**\*AN6C44A\***

Bolt

\*\*

*ll 11/03/24*

Location

Loc Qty

Loc Code

FG	2
103964	2
ST340	50
123900	50
ST341	4
m127300	4

*M128319*

*✓*

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Page 8



# Picklist Print

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Page 9

Work Order ID: 111268

**\*111268\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float  
Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

MS21083C8 Purchased No 230 Each 85.0000

Start Qty: 1.00

Required Qty: 1.00

**\*MS21083C8\***

Nut

\*\*

11/03/25

Location

Loc Qty

Loc Code

ST319

85

m127255

35

m127813

50

1120119

X1

D3631-1 Manufactured No

230 Each

112.0000

8

8

**\*D3631-1\***

Washer

\*\*

11/03/25

Location

Loc Qty

Loc Code

FP001

112

107324

12

110258

100

B111019

X9

NAS1149C0332R Purchased No

230 Each

11,566.00

4

4

**\*NAS1149C0332R\***

WASHER

\*\*

11/03/25

Location

Loc Qty

Loc Code

GA

1233

125654

1233

st510

10333

m126319

2433

m127306

2500

m127410

3000

m127831

2400

X4

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Page 9





# Picklist Print

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Page 10

Work Order ID: 111268

**\*111268\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

D2745

Manufactured No

230

Each

Start Qty: 1.00  
229.0000 8 8

Required Qty: 1.00

**\*D2745\***

Bushing

**\*\***

11/03/25

Location

Loc Qty

ST017

229

106847

5

107336

124

110526

100

Loc Code

B111554

✓

NAS1149C0832R

Purchased No

230

Each

359.0000 1 1

**\*NAS1149C0832R\***

Washer

**\*\***

11/03/25

Location

Loc Qty

ST292

359

122441

92

m114915

117

m125807

150

Loc Code

X 1

AN3C6A

Purchased No

230

Each

535.0000 4 4

**\*AN3C6A\***

Bolt

**\*\***

11/03/25

Location

Loc Qty

FG

10

122416

10

ST513

525

m125709

525

Loc Code

M128224

X 4

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# Picklist Print

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Page 11

Work Order ID: 111268

**\*111268\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

MS21043-6

Purchased

No

230

Each

Start Qty: 1.00  
518.0000 4 4

Required Qty: 1.00

**\*MS21043-6\***

NUT

\*\*

11/03/25

Location

Loc Qty

Loc Code

FG	20
103693	20
ST315	248
m127255	248
ST509	250
m127813	250

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
XC  
\_\_\_\_\_  
\_\_\_\_\_

D3493-1

Manufactured

No

250

Each

245.0000 2 2

**\*D3493-1\***

Washer

\*\*

DAS 14-03  
28  
9-89

DAS  
06  
9-89

Location

Loc Qty

Loc Code

FG	10
97201	10
ST051	235
105613	16
107916	60
109105	159

112741  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

DAS  
31  
9-89

MS21083C8

Purchased

No

250

Each

85.0000 2 2

**\*MS21083C8\***

Nut

\*\*

11/03/25

Location

Loc Qty

Loc Code

ST319	85
m127255	35
m127813	50

11128119

\_\_\_\_\_  
XZ  
\_\_\_\_\_  
\_\_\_\_\_

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# Picklist Print

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Page 12

Work Order ID: 111268

**\*111268\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

AN8C21A

Purchased

No

250

Each

Start Qty: 1.00  
95.0000 2 2

Required Qty: 1.00

**\*AN8C21A\***

Bolt

**\*\***

*ll* 1/10/25

## Location

## Loc Qty

## Loc Code

ST	2
123966	2
st339	43
m127061	43
ST508	50
m127823	50

11128319

x 2

D2741

Manufactured

No

250

Each

39.0000 1 1

**\*D2741\***

Blade

**\*\***

*ll* 1/10/24

## Location

## Loc Qty

## Loc Code

FG	11
100664	5
85480	1
98323	5
ST466	28
107206	28

13110710

x 1

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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng		Action Description	Sign & Date	Verification	QC Inspector				
Design <input type="checkbox"/>														
Doc/Data <input type="checkbox"/>														
Equip/Tooling <input type="checkbox"/>														
Handling/Pre <input type="checkbox"/>														
Material <input type="checkbox"/>														
Operator <input type="checkbox"/>														
Offset/Setup <input type="checkbox"/>														
Process <input type="checkbox"/>														
Supplier <input type="checkbox"/>														
Training <input type="checkbox"/>														
Transport <input type="checkbox"/>														
Unapproved <input type="checkbox"/>														
<b>FAULT CATEGORY</b>														
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function				<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence			<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____			

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

#### GENERAL NOTES:

- MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2  
B OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
A	NEW ISSUE	SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

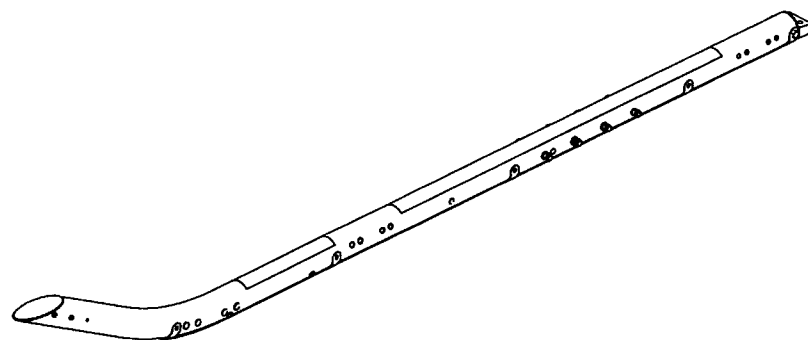
  

DART AEROSPACE USA, INC. KENT, WA	
DRAWING NO. D4168	REV. B
TITLE 350 SKIDTUBE ASSEMBLY	SHEET 1 OF 11
	SCALE NTS
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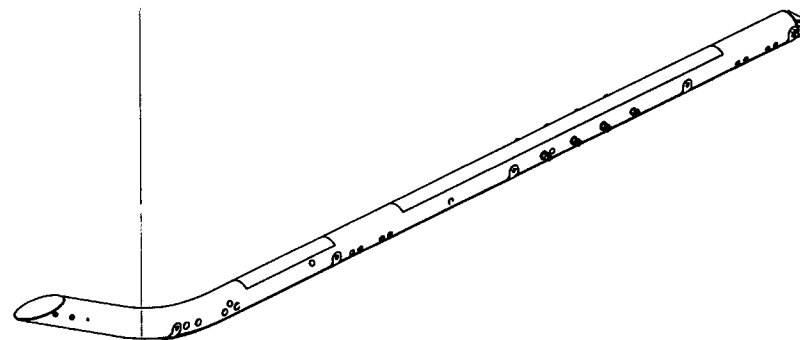
11/26/8  
2014-01-9

RELEASED  
2013-08-13  
MD





**D4168-041 350 SKIDTUBE ASSEMBLY, LH**



**D4168-042 350 SKIDTUBE ASSEMBLY, RH**

**RELEASED**  
2013-08-13  
*AW*

DESIGN  
DRAWN  
CHECKED  
MFG. APPR.  
APPROVED  
DE APPR.  
DATE 13.07.11

SC  
*[Signature]*  
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KENT, WA

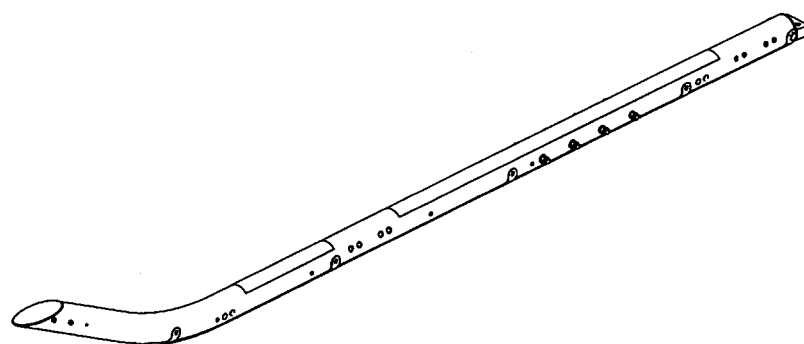
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**D4168**

TITLE  
**350 SKIDTUBE ASSEMBLY**

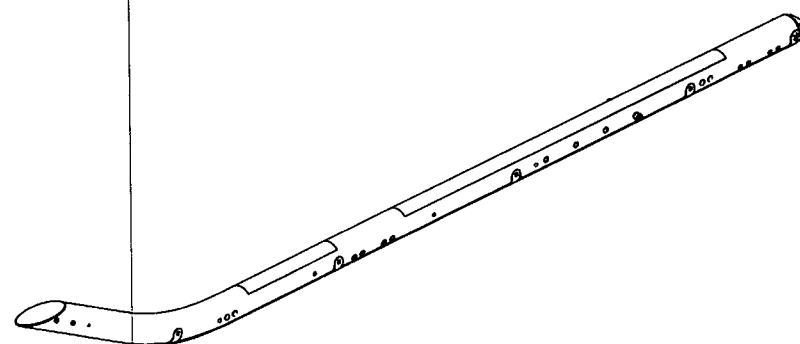
REV. B  
SHEET 2 OF 11  
SCALE  
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**D4168-043 350 SKIDTUBE ASSEMBLY, LH**



**D4168-044 350 SKIDTUBE ASSEMBLY, RH**

**RELEASED**  
2013-08-13  
*MD*

DESIGN  
DRAWN  
CHECKED  
MFG. APPR.  
APPROVED  
DE APPR.  
DATE 13.07.11

SC  
*[Signature]*

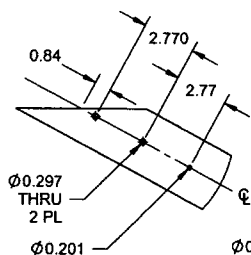
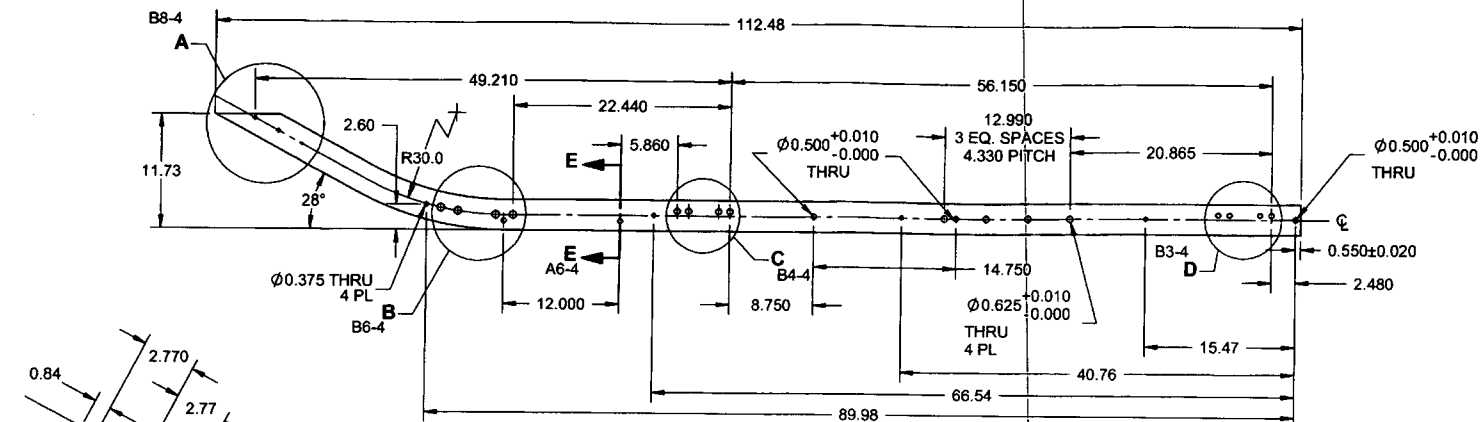
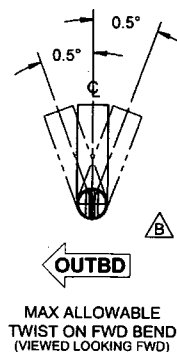
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KENT, WA

DRAWING NO.  
**D4168**

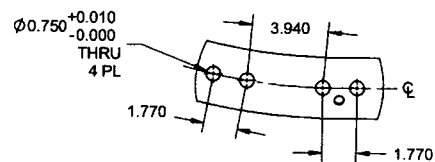
TITLE  
**350 SKIDTUBE ASSEMBLY**

REV. B  
SHEET 3 OF 11  
SCALE  
NTS  
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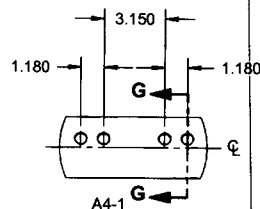
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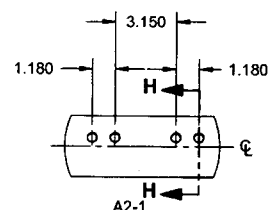
**DETAIL A**  
SCALE 2X



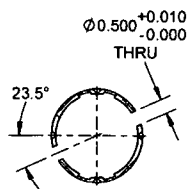
**DETAIL B**  
SCALE 2X



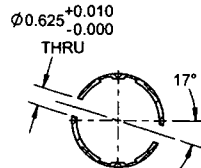
**DETAIL C**  
SCALE 2X



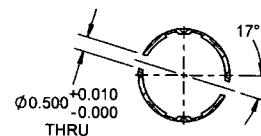
**DETAIL D**  
SCALE 2X



**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

DESIGN  
DRAWN  
CHECKED  
MFG. APPR.  
APPROVED  
DE APPR.  
DATE

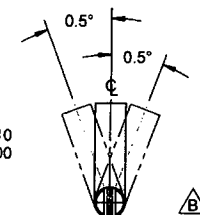
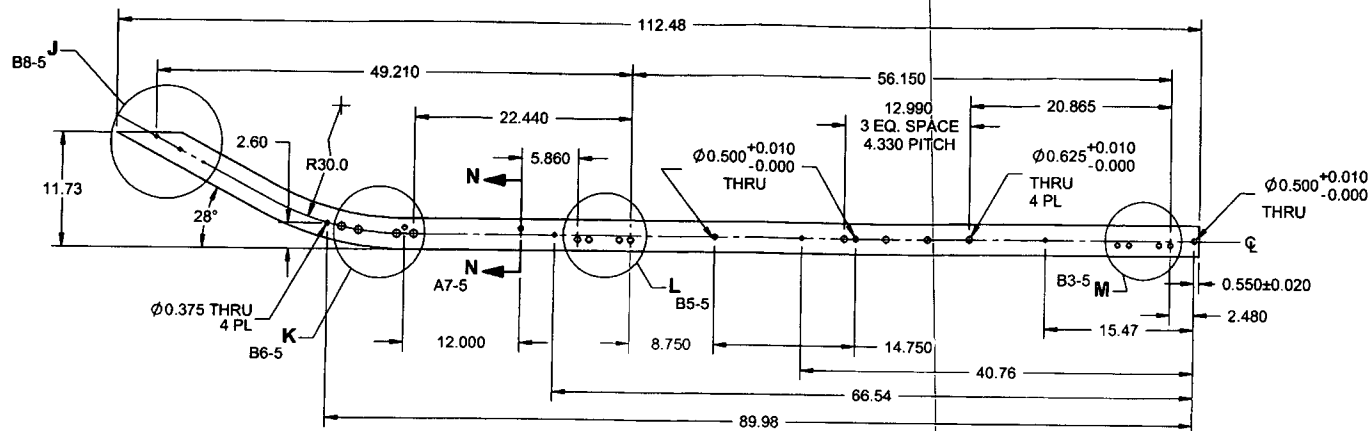
**DART AEROSPACE USA, INC.**  
KENT, WA

DRAWING NO.  
**D4168**  
TITLE  
**350 SKIDTUBE ASSEMBLY**

REV. A  
SHEET 4 OF 11  
SCALE  
NTS

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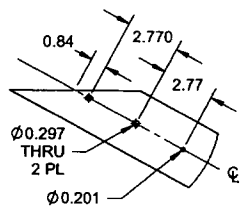
13.07.11



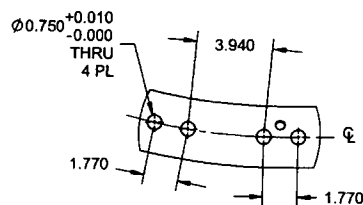
OUTBD

MAX ALLOWABLE  
TWIST ON FWD BEND  
(VIEWED LOOKING FWD)

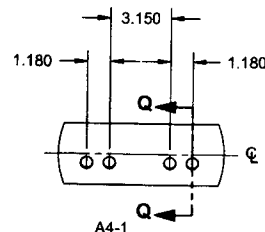
# D4168-2 RH SKIDTUBE



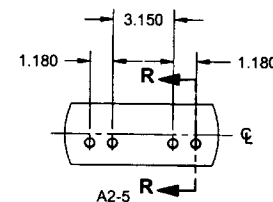
DETAIL J  
SCALE 2X



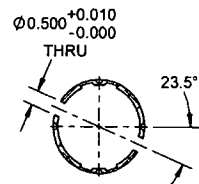
DETAIL K  
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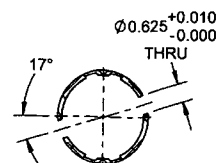
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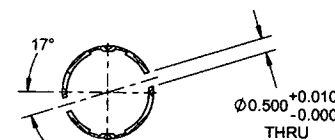
DETAIL M  
SCALE 2X



SECTION N-N  
SCALE 3X, 2 PL



SECTION Q-Q  
SCALE 3X, 4 PL



SECTION R-R  
SCALE 3X, 4 PL

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DATE 13.07.11

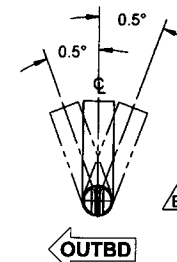
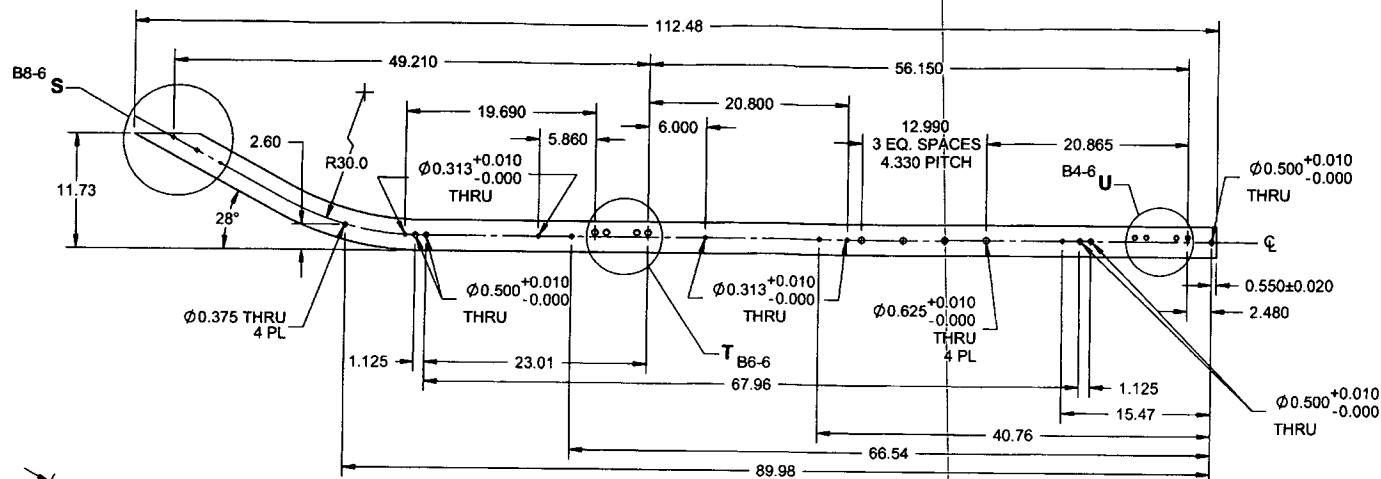
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350 SKIDTUBE ASSEMBLY

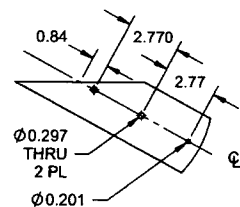
REV. B  
SHEET 5 OF 11  
SCALE  
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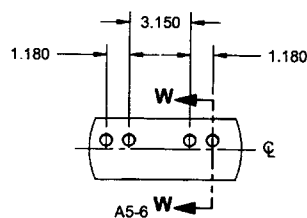
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2013-08-13



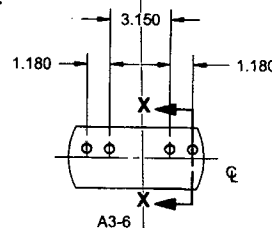
MAX ALLOWABLE  
TWIST ON FWD BEND  
(VIEWED LOOKING FWD)



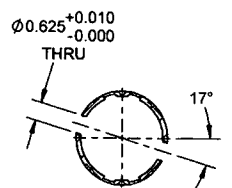
**DETAIL S**  
SCALE 2X



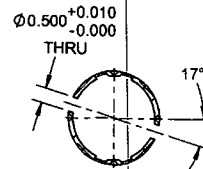
**DETAIL T**  
SCALE 2X



**DETAIL U**  
SCALE 2X



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

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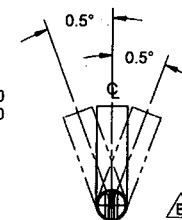
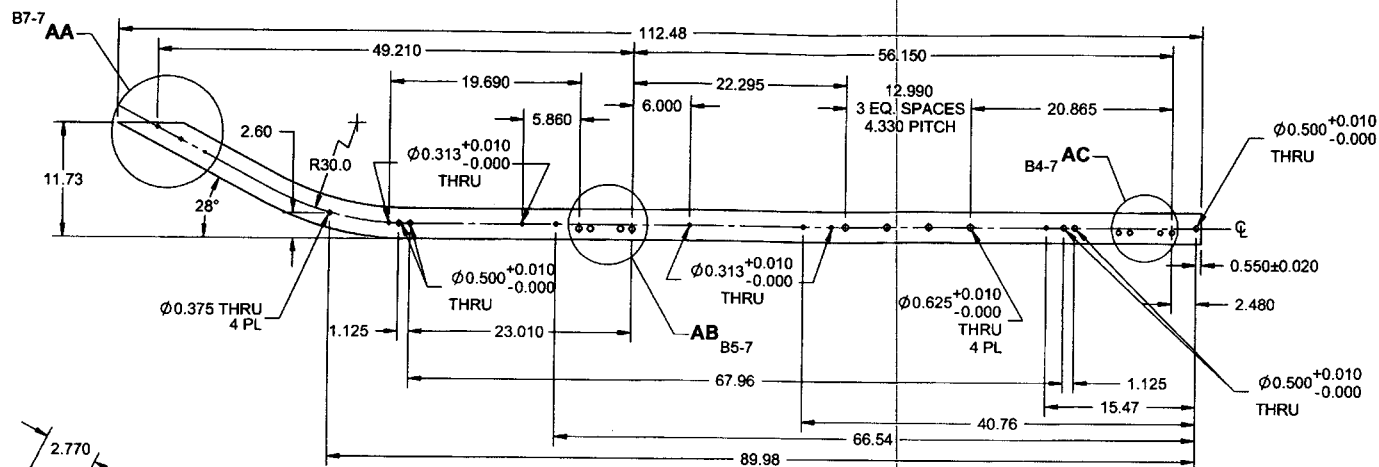
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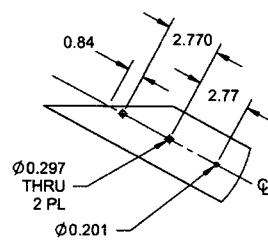
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2013-08-13

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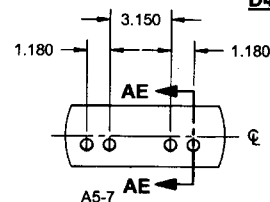


OUTBD

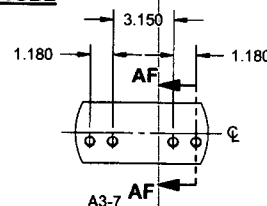
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TWIST ON FWD BEND  
(VIEWED LOOKING FWD)



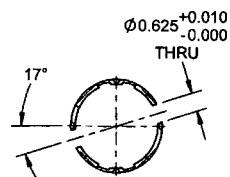
**DETAIL AA**  
SCALE 2X



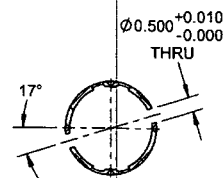
**DETAIL AB**  
SCALE 2X



**DETAIL AC**  
SCALE 2X



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

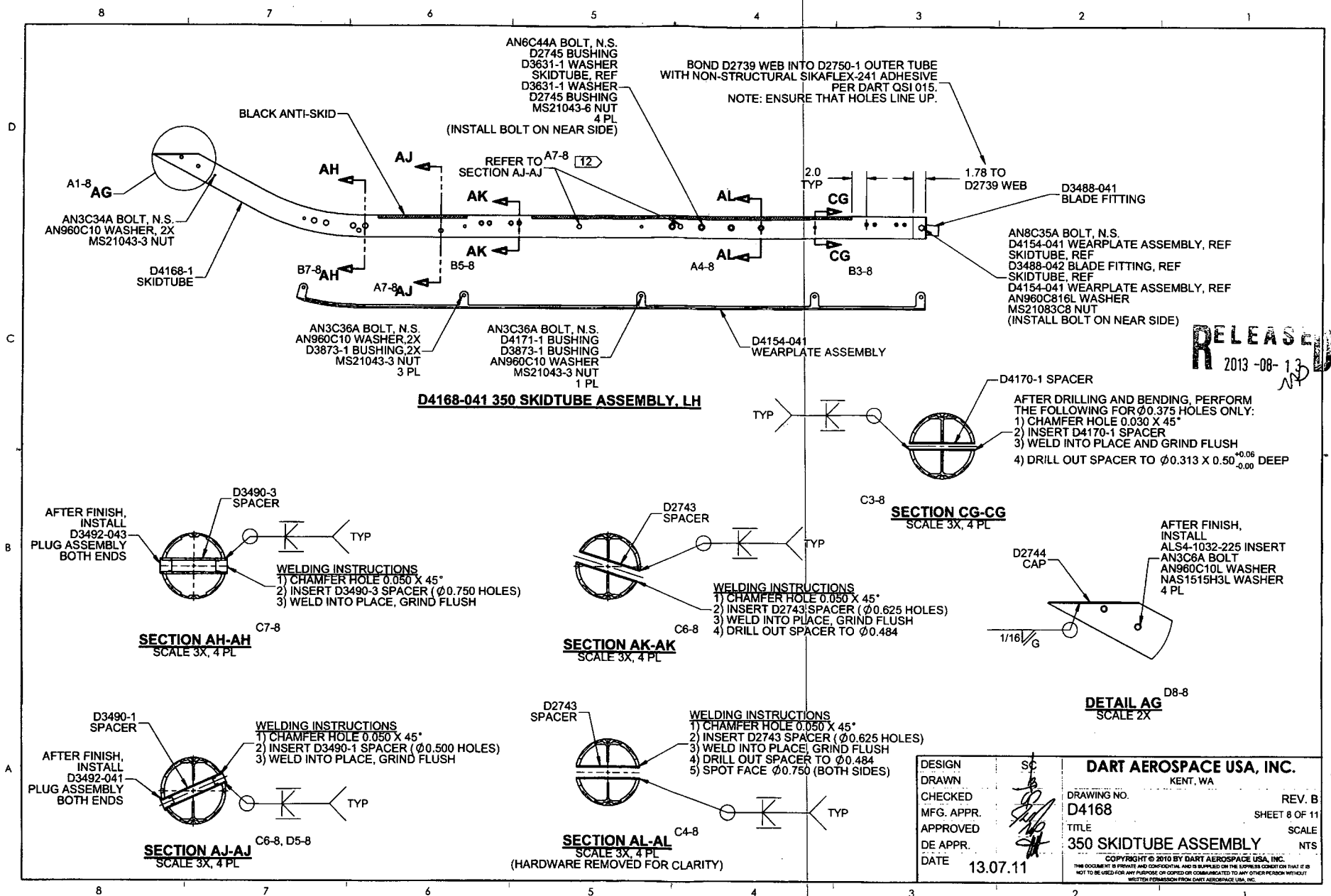
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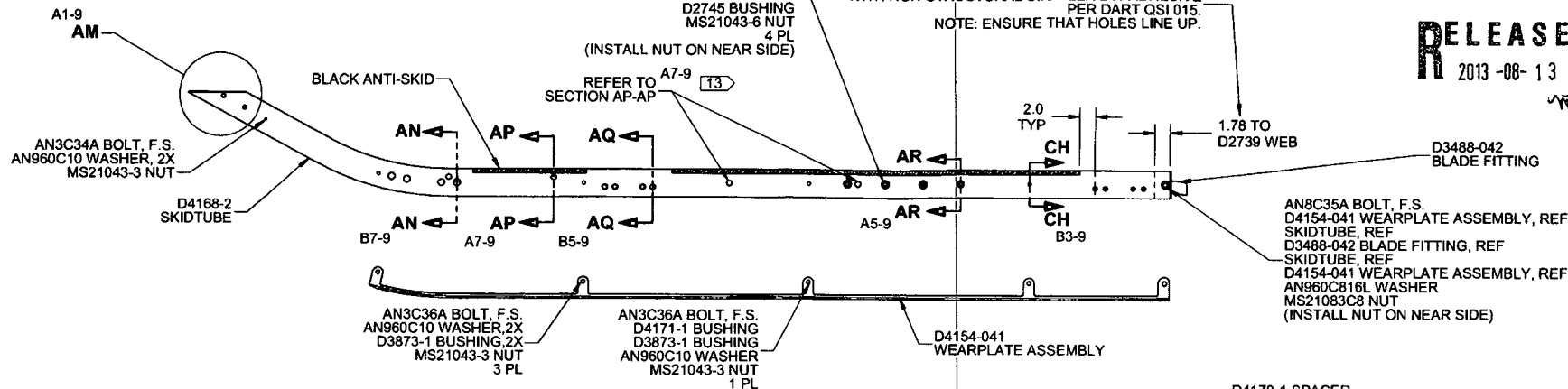




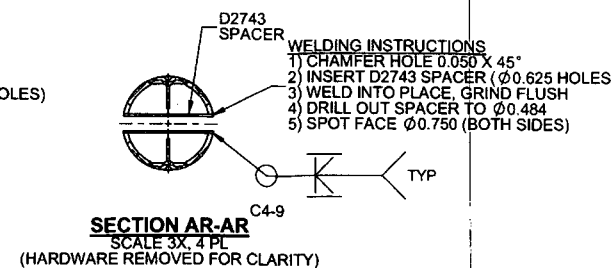
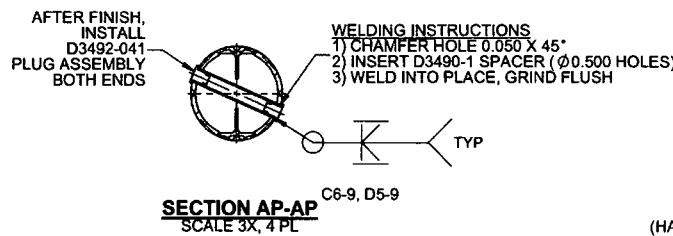
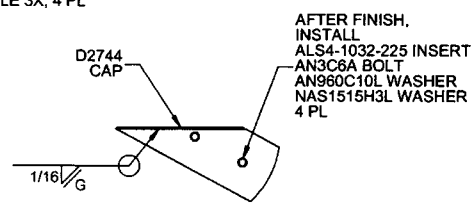
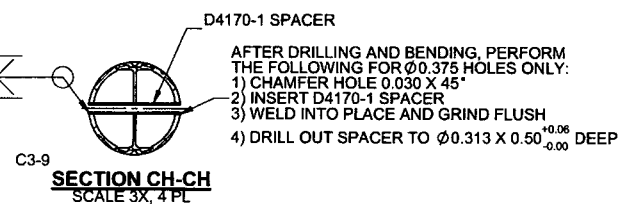
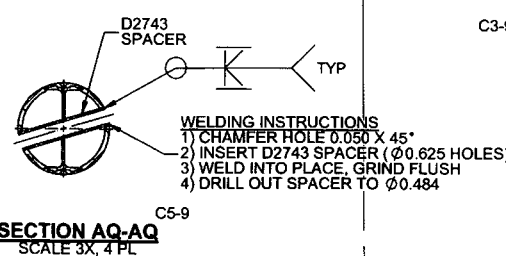
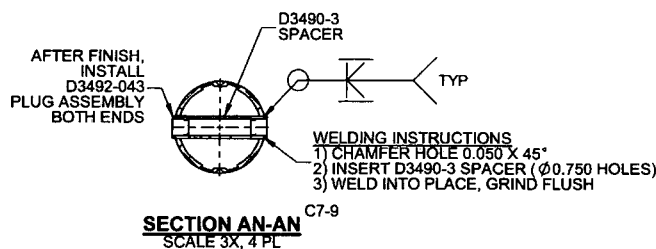
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AN6C44A BOLT, F.S.  
D2745 BUSHING  
D3631-1 WASHER  
SKIDTUBE, REF  
D3631-1 WASHER  
D2745 BUSHING  
MS21043-6 NUT 4 PL  
(INSTALL NUT ON NEAR SIDE)

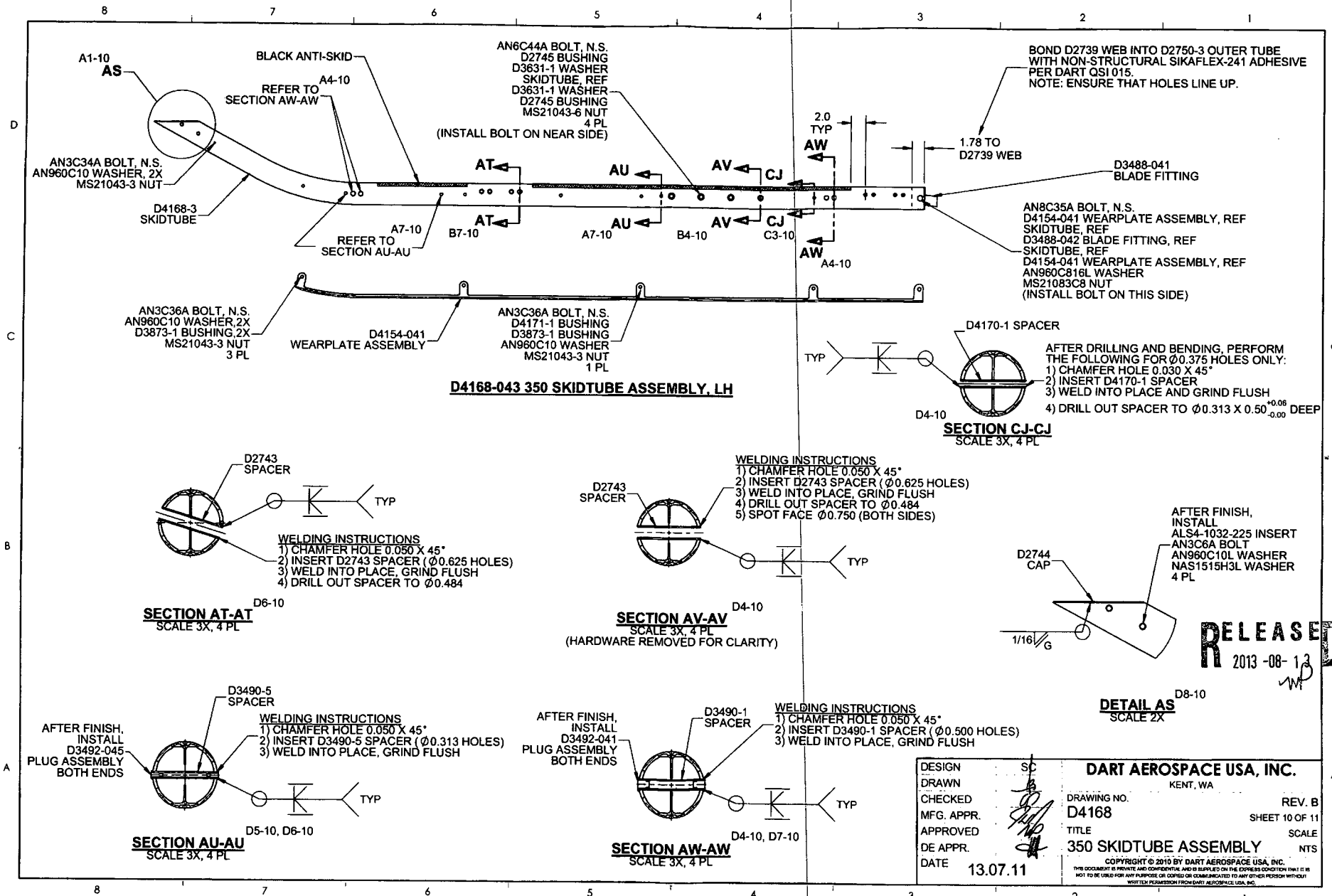
BOND D2739 WEB INTO D2750-2 OUTER TUBE  
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE  
PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.



**D4168-042 350 SKIDTUBE ASSEMBLY, RH**



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APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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No. 341

**AWS D17.1/D17.1M:2010  
SKIDTUBE WELDING TEST RECORD**

Name: Barday Elliott  
Job #: 111272  
Part #: D350-636017  
Description: 350 skid tube  
Welding Process: TIG ☒ MIG ☐  
Base Material: Aluminum  
Current: AC ☒ DC ☐

**TEST REQUIREMENTS AND RESULTS**

Visual:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Penetration:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Fusion:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Cracks:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Overlap (cold lap)	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Undercut:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Pin holes:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Porosity (surface):	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Coloration:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Burn through:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>

Qualifier: <sup>DAS</sup>  
<sub>9</sub>  
<sub>2-ec</sub>  
Barday Elliott

Date of Test Coupon: 14-03-04

Welder: Barday Elliott

Date of Test Coupon: 14-03-04

The above named individual is qualified to weld in accordance with AWS D17.1/D17.1M:2010.

